

SPECIFICATION

TITLE OF THE INVENTION

Surface treatment method using electric discharge,
5 and an electrode for the surface treatment method

TECHNICAL FIELD

The present invention in general relates to a surface
treatment method using electric discharge, and an electrode
10 for discharge surface treatment. More particularly, this
invention relates to a technology of adhering and depositing,
on the surface of a workpiece, an electrode consumed/melted
material of a discharge electrode that is generated by
discharge energy based on in-liquid discharge between the
15 discharge electrode and a workpiece, thereby forming a coat
of the material of the electrode on the surface. This
invention also relates to an electrode for the surface
treatment method using electric discharge.

20 BACKGROUND ART

The technique of adhering and depositing, on the
surface of a workpiece, an electrode consumed/melted
material of a discharge electrode that is generated by
discharge energy based on in-liquid discharge between the
25 discharge electrode and a workpiece, thereby forming a coat

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of the material of the electrode on the surface is already known (see Japanese Patent Application Laid-Open Application Nos. HEI 6-182626, HEI 9-19829, or HEI 9-192937).

In the conventional surface treatment method using
5 electric discharge, a hard coat of metal carbide or the like is formed on a surface to be treated, exclusively in order to obtain abrasion resistance.

In general, a friction surface or a sliding surface is lubricated by fluid lubrication using a liquid lubricant
10 such as a lubricating oil or grease.

However, in vacuum atmosphere such as a semiconductor production line or outer space, a liquid lubricant evaporates so that it cannot be used. In a high-temperature environment, such as an iron manufacturing line, a liquid lubricant also
15 evaporates so that it cannot be used. Thus, there are many environments in which a lubricating oil cannot be used.

Particularly in a semiconductor production line, an oily lubricant present on a sliding surface causes a serious trouble in a semiconductor production process. Therefore,
20 fluid lubrication using an oily lubricant cannot be applied thereto.

In the light of this matter, a sliding surface is coated by using a binder of a coat of a solid lubricant having self-lubricity, for example, a dicalcogen compound such as
25 MoS_2 or WS_2 , the so-called solid lubricant film, or by ion

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plating.

However, the solid lubricant film resulting from the coating method in the prior art has a drawback that the film has a restrictive life span. The ion plating has drawbacks that the device for it becomes large-sized and the size of a workpiece that can be processed is restrictive.

The present invention has been made to solve the above-mentioned problems. An object of the invention is to provide a surface treatment method making it possible to form a satisfactory and long-lived solid lubricant film on a sliding surface of a linear guide rail or the like surface without use of a large-sized device or limitation of the size of a workpiece; and a discharge electrode used in this surface treatment method.

DISCLOSURE OF THE INVENTION

The present invention provides a surface treatment method comprising the steps of using a discharge electrode comprising a material having solid lubricant effect to generate discharge in a pulse form between the discharge electrode and a workpiece, the surface of which is to be treated, in working liquid containing no carbon components, and adhering and depositing an electrode consumed/melted material of the discharge electrode that is generated by discharge energy based on the pulse form discharge onto a

surface to be treated of the workpiece so as to form a coat having lubricant effect on the above-mentioned surface.

According to the above-mentioned method, the electrode material of the discharge electrode involving solid lubricant effect adheres and deposits, as the material having
5 solid lubricant effect is, onto the surface to be treated without a change into a compound with carbon or the like, so that a coat having lubricity, that is, a solid lubricant film on the surface can be satisfactorily formed.

10 This solid lubricant film, which is different from films used in ion plating and so on, does not generate a distinct boundary which is present between the film and the base material and is a characteristic of surface treatment method using electric discharge. Inclination material
15 property is exhibited between the film and the base material so that the film becomes a film that has strong adhesion power to the base material.

The pulse form discharge in the working liquid is performed by jetting the working liquid between the discharge
20 electrode and the workpiece through nozzles, besides discharging electricity in a working bath in which the working liquid is stored.

The present invention also provides a surface treatment method using electric discharge wherein as the
25 material having solid lubricant effect, there is used

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molybdenum, molybdenum disulfide, boron nitride, tungsten disulfide, carbon, silver, gold, lead, tin, indium, nickel, or turcrite, which is a compound of carbon and fluorine.

According to the above-mentioned method, the electrode material of the discharge electrode comprising molybdenum, molybdenum disulfide, boron nitride, tungsten disulfide, carbon, silver, gold, lead, tin, indium, nickel, or turcrite, which is a compound of carbon and fluorine adheres and deposits onto the surface to be treated so as to make it possible to form, on the surface to be treated, a lubricant coat (solid lubricant film) comprising molybdenum, molybdenum disulfide, boron nitride, tungsten disulfide, carbon, silver, gold, lead, tin, indium, nickel, or turcrite, which is a compound of carbon and fluorine.

The present invention also provides a surface treatment method using electric discharge wherein water is used as the working liquid containing no carbon components.

According to the above-mentioned method, since water is used as the working liquid, the electrode material having solid lubricant effect adheres and deposits, as the material having solid lubricant effect is, onto the surface to be treated, without conversion of the electrode material to a compound with carbon or the like. As a result, a lubricant coat (solid lubricant film) can be formed on the surface to be treated.

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Referring to the attached drawings, preferred embodiments according to the present invention will be described.

20 compressed electrode 3 and the work W , legend 6 denotes a
control circuit for controlling on/off states of the switch
5, and legend 7 denotes a resistor.

In the surface treatment method using electric discharge according to the present invention, as the
25 discharge electrode 3, there is used a powder compressed

electrode wherein Mo (molybdenum) powder is compression-molded, or a Ti-based electrode containing Mo powder. As working liquid, tap water, treated water or pure water that contains no carbon component is used.

5 In the working liquid, a gap between the discharge
electrode 3 and work 100, that is, a discharge gap is
controlled to an appropriate gap (10 μm to several ten μm)
by a well-known and non-illustrated position control
mechanism that an ordinary discharge working machine has,
10 and then a discharge voltage is intermittently applied
between the discharge electrode 3 and the work 100. In this
way, discharge in a pulse form is generated between the
discharge electrode 3 and the work 100 in water.

As a result, the discharge electrode 3 is consumed
15 by the energy of this discharge. An electrode
consumed/melted material of the discharge electrode 3
adheres and deposits onto the surface to be treated of the
work 100 so that a solid lubricant film 101 having solid
lubricant effect by molybdenum is formed on the surface to
20 be treated.

In the case that a Mo powder compressed electrode is used to form a coat onto a steel material, the boundary between the coat and the base material (steel material) is hardly found, and the formed molybdenum coat has very strong adhesion power. In such a way, it is possible to obtain

a solid lubricant film that has a long life span.

Any molybdenum coat has self-lubricity as a solid lubricant and can be applied to mechanical parts used in a vacuum device or outer space.

5 Examples of the above-mentioned material having self-lubricity (solid lubricant material) include silver Ag, gold Au, lead Pb, tin Sn, indium In, soft metals such as nickel Ni, molybdenum disulfide MoS_2 , boron nitride BN, tungsten disulfide WS_2 , layered crystal materials known as
10 solid lubricants, and turcote, which is a compound of carbon and fluorine (PFPE resin). Even if a powder compressed electrode or a metal electrode comprising one or more thereof, besides the powder compressed electrode made of molybdenum, a solid lubricant film having lubricant effect and a long
15 life span can be formed on the surface to be treated of a workpiece.

 In general, a lubricant such as a lubricating oil or grease is used for lubrication. However, there are many environments in which a lubricant cannot be used. For
20 example, in vacuum atmosphere such as a semiconductor production line, a lubricant evaporates so that it cannot be used. In a high-temperature environment, such as an iron manufacturing line, a lubricant also evaporates so that it cannot be used.

25 In vacuum atmosphere such as a semiconductor

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production line or outer space, and in a high-temperature environment such as an iron manufacturing line, a liquid lubricant evaporates in the process of use thereof. Therefore, it is significant that onto mechanical parts used in an environment wherein a liquid lubricant cannot be used, a coat having the above-mentioned self-lubricity and strong adhesion power to the base material (solid lubricant film) is formed by a simple device corresponding to an electric discharge working machine.

When the work is a long product such as a liner guide rail, in-liquid discharge similar to the in-liquid discharge in the working bath can be performed by spraying water, which is the working liquid, from a nozzle 10 to a discharge gap between the discharge electrode 3 and the linear guide rail 110, as shown in Fig. 2. In Fig. 2, to parts corresponding to those in Fig. 1 are attached the same reference numbers as attached in Fig. 1, and explanation of the parts is omitted.

In this case, the gap between the discharge electrode 3 and the linear guide rail 110, which is a work, that is, the discharge gap is controlled to an appropriate gap (10 μm to several ten μm). While water, which is the working liquid, is sprayed from the nozzle 10 thereto, a discharge voltage is intermittently applied between the discharge electrode 3 and the linear guide rail 110. In this way, discharge in a pulse form is generated between the discharge

electrode 3 and the work 110 in water.

As a result, the discharge electrode 3 is consumed by discharge energy. An electrode consumed/melted material of the discharge electrode 3 adheres and deposits onto the surface to be treated of the linear guide rail 110 to form a self-lubricity coat having lubricant effect, for example, molybdenum, that is, a solid lubricant film 111 on the surface to be treated. In this way, it is possible to obtain a linear guide that can be used even in vacuum atmosphere or in a high-temperature environment and has self-lubricity.

INDUSTRIAL APPLICABILITY

As described above, the surface treatment method using electric discharge according to the present invention makes it possible to give effectively solid lubricant effect to a member, for which a liquid lubricant cannot be used since the member is used in vacuum atmosphere or in a high-temperature environment, by a self-lubricant coat. The present process can be used in mechanical parts used in vacuum atmosphere or in a high-temperature environment.